Work Orde October-07-13		7990		*107	7990*						Page 1
Item ID: Revision ID:	D4091-1		, A	Accept	*N900	040	100)* s	etup Star Stop	I VI	S1*
Item Name: Start Date: Required Date: Reference:	Mounting Lug 10/02/13 10/07/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:				TN.	S2*
Approvals:		in: MCZ	Date: 13-10-08			ate:		R	dun Star Stop	``I \ I	R1* R2*
Sequence ID/ Work Center II		Operation Description	· · · · · · · · · · · · · · · · · · ·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D4091	A	<u></u>									
*100 *100* Bandsaw Jeaspa Bandsaw		Memo CUT BLAN	K1.450" LONG	0.00				Co	Z 13/	10/1	720
HAAS I CA	urohus Il machine #1	Memo MACHINE FOLIO REV DWG REV:		0.00 0.00 D DWG				, C C	L 131	, 10/17	20
		DEBURR 🛶	issue P nachihe	to to w	retec due DA	1091 I	REU). A			

NCR: Y	·												
											QA Closed:	Date	:
Work Orde	er: _	· · · · · · · · · · · · · · · · · · ·				DISPOSITION	1			AGAINST DE	PARTMENT	_	- —
Part N	-					Rework Scrap Use-as-is Work Order Update		t Therm	Machining	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
NCK	٠٠.	·		<u> </u>		Work Order opuate	J		raige rab	composite		3applier_	
Root					Descri	ption of work order update	ĺ	nitial	Action	n	Sign &	· · · · · · · · · · · · · · · · · · ·	
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descript	tion	Date	Verification	QC Inspector
Doc/Data	\Box												
Equip/Tooling	Ш												
Operator	Ц												
Material													
Setup													
Other	Ш												
Process													
Supplier						•							
Training	Ш												
Unapproved				<u></u>			<u>.</u>						
						F.	AUL	T CATE	GORY				
Landi					_	General	_	1		_	1	_	_
	-	Bending				Bend	lacksquare	Grain		<u> </u>	Ovalized	-	Pressure/Forced
	Ш	Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		1	ion Incomplete		Part Incorre	ct	Weld
		Crushed/6	Crimped,			Burrs						Wrong Stock Pulled	
		Cuffs				Contamination		Mainte	nance	· <u> </u>	Part Moved		
		Heat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	
		Inspection	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other
Ripples in Bend Drill Holes Offset													

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord October-07-13		7990		*107	7990*	. w wants were sweens	·					Page 2
Item ID: Revision ID: Item Name:	D4091-1 Mounting Lug	5	,	Accept	*N900	040	100)* s	Setup S	tart Stop	*N:	S1*
Start Date: Required Date: Reference:	10/02/13 10/07/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:						
Approvals:		ın:		Tooling: SPC (Y/N):		ate:		F		tart Stop	*NI *NI	₹1* ₹2*
Sequence ID/ Work Center II 120 LOC CL *120* QC Quality Control	•	Operation Description QC2-Inspect parts off ma Memo VIO'CL + May Attended a f		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp
*130 *130* QC Quality Control		QC&-Inspect parts - seco		0.00 27 9-89 0.00 3 10 3	29		G	DO J				
140 *140* HandFinish		Chemical Conversion Co	oat per QSI005 4.1	0.00				20	H	3	00	30

Hand Finishing

						DQA:	Date:	
es / No			WORK ORDER NON-C	CONFORI	MANCE / UPDATE		Date:	•
··			DISPOSITION		A	GAINST DEPARTMENT	/PROCESS	
0			Rework Scrap Use-as-is Work Order Update		Machining Sn noforming Fi	nall Fab Pro inishing Rec/Sto		Engineering Quality Other
	T		Description of work order update	Initial	Action	Sign &		
Date	Step	Qty	or Non-conformance	Chief Eng	Description	n Date	Verification	QC Inspector
-								
1								
	1					1		
	es / No r: lo. Date	r:	r:	r: DISPOSITION Rework Scrap Use-as-is Work Order Update Description of work order update	r: DISPOSITION Rework	r: DISPOSITION Additional Content of the conte	WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: DISPOSITION Rework Scrap Use-as-is Use-as-is Work Order Update Description of work order update Description of work order update Description of work order update OA Closed: AGAINST DEPARTMENT, Skid-tube Machining Small Fab Pro Thermoforming Large Fab Composite Description of work order update Description of work order update	WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date: DISPOSITION Rework Scrap Use-as-is Work Order Update Description of work order update Description of work order update NORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date: Crosstube Machining Small Fab Prod. Eng. Coor. Rec/Store/Packaging Supplier Description of work order update Initial Action Sign &

			FAUI	LT CATEGORY		
Landing	Gear	General			_	
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset	 _	
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio		Outside Dimensions		

Training Unapproved

Work Orde				*107	7990*							Page 3	3
Revision ID:	D4091-1			Accept	*N900	040	100)*	Setup	Start Stop	ı u.	S1* S2*	
Start Date: Required Date: Reference:	10/02/13 10/07/13		*20* *20*		Cust Item II Customer:	D :				6 4 4			
Approvals:		s Plan:	Date:		Da				Run	Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center II 150 *150* Powdercoat Powder Coating	0	Operation Description White Gloss(Ref:4.3.5.1) MIDG175 Memo	per QSI005 4.3-Alum	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty 28	Rej Qty		Reject Number	Insp. Stamp DAS 34	1

DAS QC3- Inspect Part Finish 0.00 160 27 9-89 *160* 0.00 Memo B 10:30 Quality Control

Identify as per dwg & Stock Location: 51/49 0.00 170 *170*

Memo

0.00

13/10/3/ 20

Packaging Packaging

			DQA:	Date:
NCR:	Yes /	NO WORK ORDER NON-CONFORMANCE / UPDATE		

										QA Closed:	Date):
Work Orde	er:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	- - 10.	•				Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining rmoforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	\neg				Descri	ption of work order update	Initial	A	ction	Sign &		
Cause		Date	Step	Qty	•	or Non-conformance	Chief Er	g Des	cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material	_											
Setup	\Box											
Other]										
Process												}
Supplier								1				
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						· · · · · · · · · · · · · · · · · · ·	AULT CA	EGORY				
Landii					_	General .	<u> </u>			1	_	-
	-	Bending				Bend	Grain		<u> </u>	Ovalized	-	Pressure/Forced
		Centre No	ot Concer	ntric to	^{D/S} -	BOM/Route	Hard		<u> </u>	Over/Under	├	Temperature/Cure
	-	Cracks	.		<u> </u>	Broken/Damaged	—	ction Incomplete	,, , <u> </u>	Part Incorre	}	Weld
	Crushed/Crimped.				-	Burrs	\vdash	ctions Incomplete	e/Unclear	Part Lost/M		Wrong Stock Pulled
	Cuffs			-	Contamination	\mapsto	tenance	<u> </u>	Part Moved			
	Heat Treat Inspection Strip in Tube			Countersink	⊢⊣	beled		Positioned \		Other		
				\vdash	Cut Too Short Drill Holes	Misre		L_	Power Loss/	Surge	Other	
				, ⊢	Drawing	Offset						
, <u>, , , , , , , , , , , , , , , , , , </u>					'	Finish	Out of Calibration					
Turning Sequence Wave/Twist in Tube					-	Folio	Out of Sequence Outside Dimensions					

Work Ord October-07-13		7990		*107	7990*							Page 4	4
Item ID: Revision ID: Item Name:	D4091-1 Mounting Lu	g		Accept	*N900	040	100)* s	etup S	Start Stop		S1* S2*	
Start Date: Required Date: Reference:	10/02/13 : 10/07/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:				0			
Approvals:		an:	Date:	Tooling: SPC (Y/N):		ate:		R		Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center I 180 *180* QC Quality Control	D	Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp	37

											DQA:	Dat	e: _	
NCR:	Yes	/ No				WORK ORDER NON-C	100	VFORM	MANCE / UPD	DATE				•
											QA Closed:	Dat	e:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS		
	•					Rework			Skid-tube	Crosstube		Water Jet		Engineering
Part I	No.		·			Scrap	-		Machining	Small Fab	1	d. Eng. Coor. re/Packaging	\dashv	Quality Other
NCR I	No.					Use-as-is Work Order Update]		noforming Large Fab	Finishing Composite	Rec/Stol	Supplier		Other
Root					Descri	ption of work order update	П	Initial	Acti	ion	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	_	QC Inspector
Doc/Data														
Equip/Tooling	Ш		•				į							
Operator	Ш													
Material	Ш													
Setup	Ш													
Other	Ш				i.		1							
Process														
Supplier											!			
Training														
Unapproved														L
							AUL	LT CATE	GORY					
Landi					_	General	_	7		_	7	,		1
		Bending				Bend		Grain			Ovalized			Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route	L	Hardwa	re		Over/Under	tolerance		Temperature/Cure
	Ш	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct		Weld
	Ш	Crushed/	Crimped.			Burrs	L	Instruct	ions Incomplete/U	Inclear	Part Lost/M	issing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved			
		Heat Trea	at			Countersink		Mislabe	eled		Positioned \	N rong		
		Inspectio	n Strip in	Tube		Cut Too Short	Misread Power Loss/Surge Other				Other			
		Ripples in	Bend			Drill Holes		Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

October-07-13 9:05:56 AM

Work Order ID:

107990

Parent Item:

D4091-1

Parent Item Name:

Mounting Lug

Start Date: 10/02/13

Required Date: 10/07/13

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP REV :A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	526.6900	0.1251	2.633684	~ V	12/10	117
Lug Extrusion											$-\alpha$		/_/
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT006		526:69							

D4091-17

120

[v/3/10/28 (20)

		DQA:	Date:	
NCR· Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			•

											QA Closed:	Dat	e:
Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N	No.					Rework Scrap Use-as-is	-	۱ Therm	Skid-tube Machining Moforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No.						Work Order Update	J		Large Fab	Composite	J	Supplier	
Root		Date	Cton	Otv	1	ption of work order update or Non-conformance	1	tial f Eng		ction	Sign & Date	Verification	QC Inspector
Cause Doc/Data		Date	Step	Qty	,	or Won-comormance	Citie	i ciig	Desc	cription	Date	verification	QC IIISPECTOI
Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
	FAULT CATEGORY												
Landing Gear General													
		Bending Centre No Cracks Crushed/G Cuffs Heat Trea Inspection Ripples in	Crimped at n Strip in i Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes	H Ir	nstruct Mainte Mislabe Misreac Offset	on Incomplete ions Incomplete, nance led	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned \(\) Power Loss/	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Torque W			n L	Drawing	\vdash		Calibration	-			
	-	Turning S Wave/Tw			-	Finish Folio	_		Sequence Dimensions		 		

D4001-1

D4091-1 MOUNTING LUG

107990MLJ 13-10-08 D

С

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RELEASED 2010 -04-29

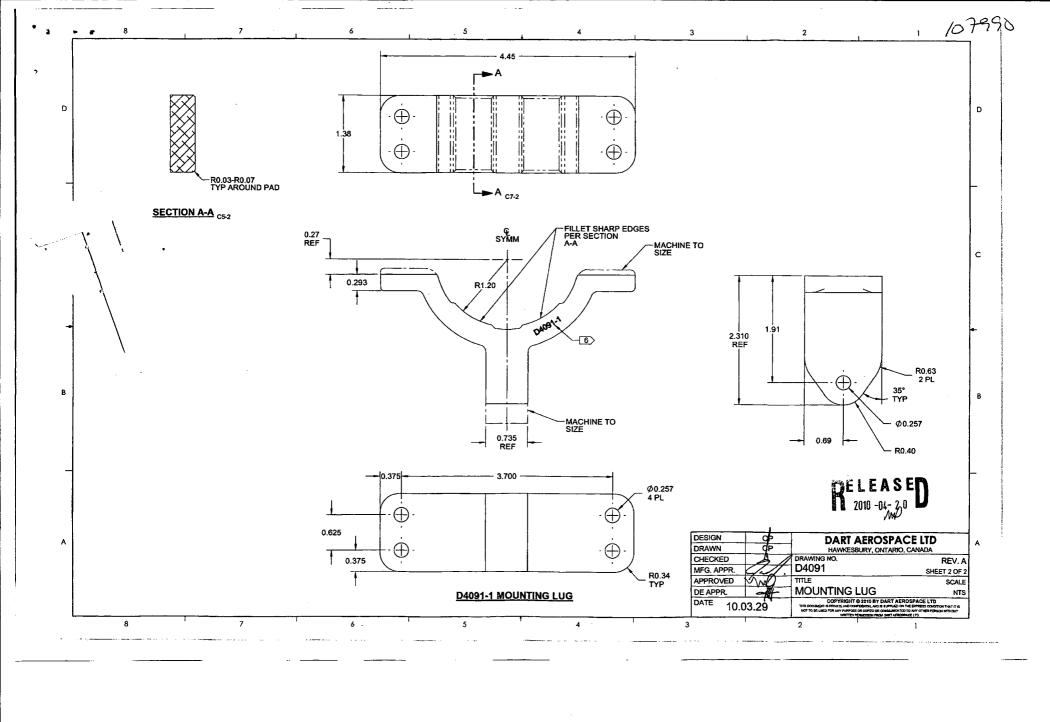
NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.9.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 ± 0.005
7) WEIGHT: 0.31 lbs

4 2

8

8

Α	NEW IS	SUE		CP	10.03.29		
REV.			DESCRIPTION	BY	DATE		
DESIGN CP			DART AEROSPACE LTD				
DRAWN		CP	HAWKESBURY, ONTARIO, CANADA				
CHECKED		31	DRAWING NO.		REV. A		
MFG. APPR.			D4091		SHEET 1 OF 2		
APPROVED /		AND	TITLE		SCALE		
DE APPR.		44	MOUNTING LUG		NTS		
DATE	10.0	3.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIMATE AND CONFEDURAL WIS SUPPLED ON THE COPYRES COMMENTAL THAT IT IS NOT TO DE LIBER FOR ANY PARPOSE OR OFFED OR COMMENTALITY TO ANY COMPRESS PRIMATED TO ANY COMP				





Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO21734

Purchase Order Date 10/17/2013 **PO Print Date** 10/17/2013

Page Number 1 of 1

Order From:

 $\mathsf{C}\mathsf{A}$

VC-MET003

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

[67/3/n/18

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone Ship Via:

Ship Acct:

613 678 3957

METEC METAL TECHNOLOGY INC.

20 TERRY FOX DRIVE PO BOX 781 VANKLEEK HILL, ON K0B 1R0

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ CD Taxable Promise Date	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4091-1P	Lug	10/25/2013 Yes 10/25/2013	20.00 Each	\$26.95	\$539.00
	AS PER DWG D4091 REV. A B107990					

Line Total:

\$539.00

PO Total:

\$539.00

 \mathcal{V} (

NO

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required (YES

PST# 6122-5207

1

Change Nbr: .

Change Date: 10/17/2013



20 Terry Fox Drive Vankleek Hill, Ontario K0B 1R0, Canada Tel: (613) 678-3957 Fax: (613) 678-3956

Delivery Slip No.:

19313

Date:

Oct 25, 2013

Page:

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 21734	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date:

- Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity		
D4091-1 Lug as per drawing D4091 Rev.A	Each	20	20			
			·			
	-					
ne delivered goods must be inspected upon receipt to confirm compliance. nould there be discrepancies please notify METEC within 30 days of delivery, he goods are otherwise deemed accepted.						
Received by	Thank	Thank you for your order!				

20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0 Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 <u>metec@metec.ca</u>

CERTIFICATE OF CONFORMITY

SOLD TO:

SHIPPED TO:

Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ont.

same

K6A 1K7

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

20

D4091-1

Lug as per drawing D4091 Rev.A

21734

MATERIAL: supplied by DART B93551

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shiqi Walz

Vankleek Hill, October 25, 2013